

Work Order ID 164068

Thursday, July 13, 2017 11:44:36 AM

164068

Page 1

Item ID: D5076-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Inboard Bracket Assembly
 Start Date: 8/3/2017 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/10/2017 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: JUL 13 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5076	A ✓								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120		0.21							
120									
Small Fab	Memo	2.19							
Small Fab	1-Assemble as per dwg, do not install grommets and rubber seal.								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.04							
Quality Control									

2 DAS 6 JUL 20 2017
9-89
2 Ø JUL 27 2017 DAS 19
9-89
2 DAS 38 JUL 27 2017
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval																																																																
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				Lead hand / Supervisor Approval Verification																																																																
				QC / QA Coordinator Approval																																																																
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Work Order ID 164068

Thursday, July 13, 2017 11:44:36 AM

164068

Page 2

Item ID: D5076-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Inboard Bracket Assembly
Start Date: 8/3/2017 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 8/10/2017 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
140									
Powdercoat	Memo <i>M 136370</i> 0.49								
Powder Coating	*** MASK NUT PLATE HOLES PER DWG ***								
	START TIME: <i>4:30</i>								
	OVEN TEMPERATURE: <i>320</i>								
	FINISH TIME: <i>5:00</i>								
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.02							
Quality Control									

DAS
30
9-89

2 0170731.

JUL 17 2017

AUG 01 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DAS
38
9-80
AUG 01 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 164068

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164068

Page 4

Item ID: D5076-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Inboard Bracket Assembly
Start Date: 8/3/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 8/10/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>SH2/7</u>	0.00							
180									
Packaging	Memo	0.02							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.20							
Quality Control									

2 AUG 01 2017 DAS 6 9-89

17/8/2017

DAS
21
9-89

AUG 01 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐		No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐		Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐		Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐		Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐		Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐		Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐		Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐		Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐		Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐		Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐		Manufacturing Process	☐	OTHER :						
Misidentified	☐		Past Due	☐							

Picklist Print

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Page 1

Work Order ID: 164068

164068

Parent Item: D5076-043

D5076-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 8/3/2017

Required Date: 8/10/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.04.01 PER DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4434-9 *D4434-9* Bracket		Manufactured	No			110	Each	6.0000	1	2	DAS 6 9-89	JUL 20 2017	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST613		6							
				161201		6							
D5076-1 *D5076-1* Bracket		Manufactured	No			110	Each	2.0000	1	2	DAS 6 9-89	JUL 20 2017	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST614		2							
				157292		2							
D5076-3 *D5076-3* Bracket		Manufactured	No			110	Each	2.0000	1	2	DAS 6 9-89	JUL 20 2017	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST614		2							
				157189		2							
D4435-041 *D4435-041* Bracket Assembly		Manufactured	No			160	Each	2.0000	1	2	DAS 6 9-89	JUL 20 2017	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST098		2							
				162525		2							

Picklist Print

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Work Order ID: 164068

164068

Parent Item: D5076-043

D5076-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 8/3/2017

Required Date: 8/10/2017

Start Qty: 2.00

Required Qty: 2.00

D4441-1 Manufactured No 160 f 256.4512 2.646 5,292

D4441-1

Rubber Seal

**

MCC
17-8-1

Location

Loc Qty

Loc Code

ST422

10.6392

151347

10.6392

ST625

245.812

151347

245.812

Cut qty 1 to 1.7"

D4440-1

Manufactured No

160

Each

21.0000

1

2

D4440-1

Grommet

**

MCC
17-8-1

Location

Loc Qty

Loc Code

GA

21

~~160669~~

10

163269

11

2

AN525-832R6

Purchased No

160

Each

40.0000

3

6

AN525-832R6

Screw

**

DAS
6
JUL 20 2017

Location

Loc Qty

Loc Code

GA

25

m136787

25

ST328

15

m137371

15

6

Picklist Print

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Work Order ID: 164068

164068

Parent Item: D5076-043

D5076-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 8/3/2017

Required Date: 8/10/2017

Start Qty: 2.00

Required Qty: 2.00

MS20426AD3-3

Purchased

No

110

Each

2,095.000

14

28

MS20426AD3-3

RIVET

**

JUL 27 2017

DAS
19
9-00

Location

Loc Qty

Loc Code

FG107/108

80

M137350

80

fg108

200

M134946

200

GA

48

M135274

48

ST312

1767

M135274

1767

(28)

MS20470AD4-3

Purchased

No

110

Each

1,585.000

15

30

MS20470AD4-3

Rivet, Universal Head

**

JUL 27 2017

DAS
19
9-00

Location

Loc Qty

Loc Code

GA

840

2193

87

m135536

753

ST310

745

m135536

745

(30)

MS21075L08

Purchased

No

110

Each

177.0000

7

14

MS21075L08

ANCHOR NUT

**

DAS

6

9-00

JUL 20 2017

Location

Loc Qty

Loc Code

ST298

177

M135774

102

M137597

75

M128429x4

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Shop Packet Print

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